

5/13

DART AEROSPACE LTD	Work Order:	22529
Description: Bushing	Part Number:	D2809
Dwg: D2809 rev.A1	Qty:	130

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	HA	05.02.23	130
2	COBRA	Machine as per Folio FA204 Material: 6061-T6 (QQ-A-250-11) rod .500"Ø Batch: <u>M16991</u> <u>M15107</u>		05.03.08	130
3	QC	Inspect Level 2		05.03.08	130
4	QC	Inspect Level 8		05.03.08	130
5	CNC CELL	Tumble & deburr all sharp edges as per dwg		05.03.08	130
6	QC	Inspect Level 5		05.03.08	130
7	FINISHING	Chemical conversion coat per QSI 005	M	05.03.09	130
8	FINISHING	Powder coat <u>White</u> per QSI 005 4.3	M	05.03.15	130
9	QC	Inspect Level 3	U	05.03.16	130
10	STORES	Identify and stock	U	05.03.16	130
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: <u>1.12</u> <u>545</u> <u>05/03/17</u> <u>(130)</u> <u>1.10</u>	HA	05.03.18	130

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	01.04.26	Re format	EC	
C	02.03.07	Now turned in house	NG	02.03.11

RELEASED

02/03/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

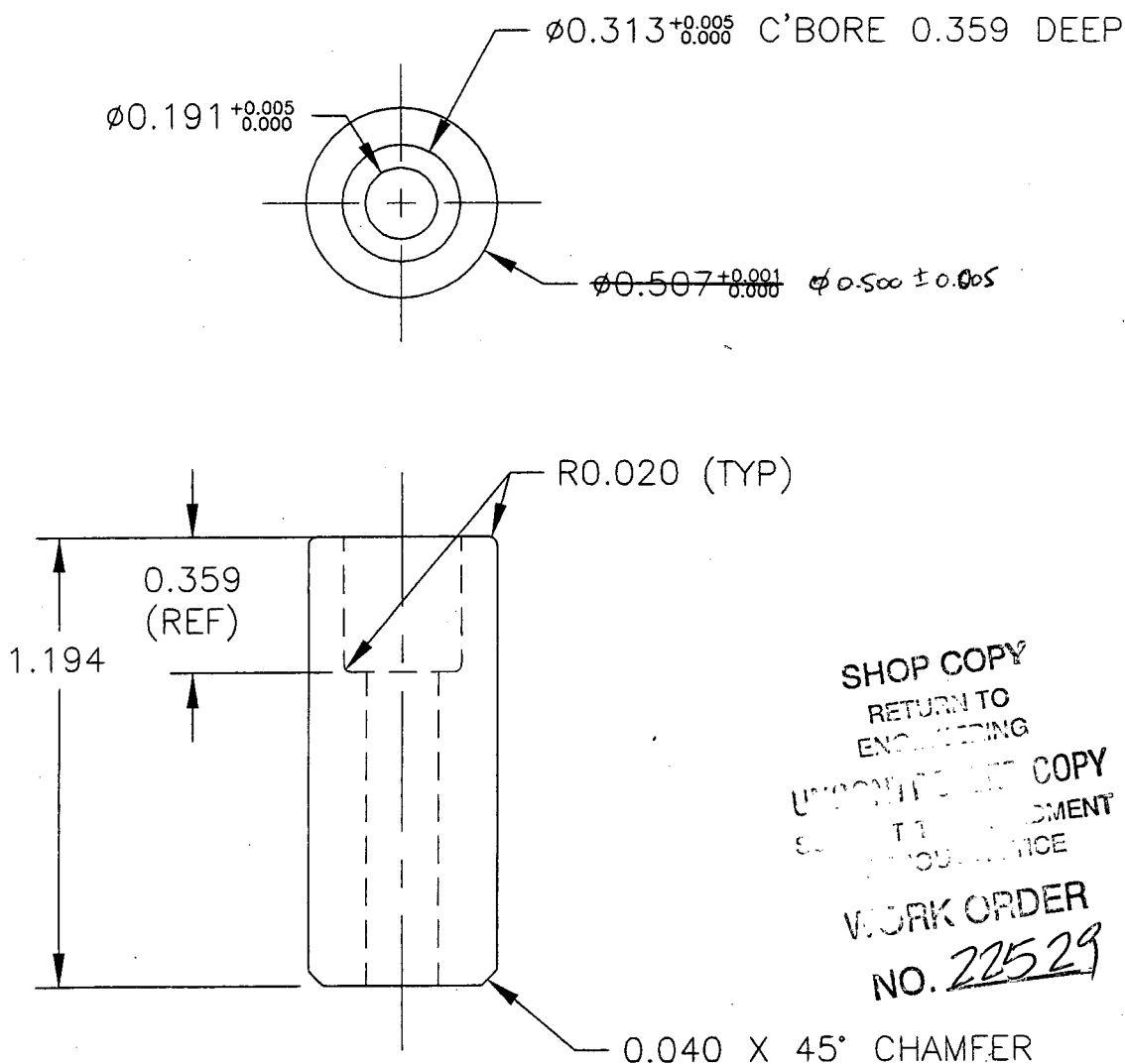
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	# CP 01.04.26	ADD POWDER COAT ; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED
00.11.13 #



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020

MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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PER DART QSI 005 4.3

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
03:39 pm

Work Order No : 0022529
Project Name : D2809
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D2809
Description : Bushing
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 02-22-05
Est Finish Date : 03-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

